

Wednesday, 5/31/2006 7:32:45 AM

User: Kim Johnston

## Process Sheet

25

**Customer** : CU-DAR001 Dart Helicopters Services  
**Job Number** : 27269  
**Estimate Number** : 12027  
**P.O. Number** : N/A  
**This Issue** : 5/31/2006 **S.O. No.** : N/A  
**Prsht Rev.** : NC  
**First Issue** : N/A **Type** : LARGE FAB ASSY  
**Previous Run** : 27089  
**Written By** : *See Comment Below*  
**Checked & Approved By** : *06.05.31 W*  
**Comment** : Est. Rev: 05.08.22 Step 3 & 5 revised per ECN 700 KJ/J LM

**Drawing Name** : PILOT/CO-PILOT STEP, RH (FOLDING)  
**Part Number** : D412630024  
**Drawing Number** : D412-630 REV. J ,P13  
**Project Number** : N/A  
**Drawing Revision** : J  
**Material** : N/A  
**Due Date** : 6/20/2006 **Qty:** 5 **Um:** Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; create labels per PPP D412-630-024 CHG002

KS 06.06.07

2.0	D2012107	Clevis
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Clevis

Pick:

Qty	Part Number	Description	Batch
1	D2012-107	Clevis	B22490 1X B25483

3.0	D2803042	Bracket Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2803-042	Bracket Assembly RH	27283 B26564 4X B26564 1X

4.0	D2804042	Bracket Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2804-042	Bracket Assembly RH	327284 3X B25920 2 2m

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 27269

Part Number: D412630024

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2807

Support Prop



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Support Prop

Pick:

Qty

Part Number

Description

Batch

2

D2807

Gas Spring

B27562

6.0

D2813

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

2

D2813

Washer

B25923

7.0

D33951

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bushing

Pick:

Qty

Part Number

Description

Batch

4

D3395-1

Bushing

B26141 /MCP B26776 19MCP

8.0

D3388042

Step Weldment RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Step Weldment RH

B27270

9.0

AN3C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

BOLT

Pick:

Qty

Part Number

Description

Batch

2

AN3C21A

Bolt

M19633

10.0

AN310C8

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nut

Pick:

Qty

Part Number

Description

Batch

✓

nut

M100433

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 27269

Part Number: D412630024

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 AN310C8 Nut

M19093

11.0

AN8C16

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description
2	AN8C16	Bolt

Batch

M100695

12.0

MS210433

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
4	MS21043-3	Nut

Batch

M19099

13.0

MS24665302

Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Cotter Pin

Pick:

Qty	Part Number	Description
2	MS24665-302	Cotter Pin (or AN380C3-4)

Batch

M16991

14.0

MS24693C280

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description
2	MS24693-C280	Screw (or MS24694-C565)

Batch

M16984

15.0

NAS1515H3

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
6	NAS1515H3	Washer

Batch

M19633

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Wednesday, 5/31/2006 7:32:46 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 27269

Part Number: D412630024

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

NAS1515H5L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description
4	NAS1515H5L	Washer

Batch

M100680

17.0

NAS1515H8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
4	NAS1515H8	Washer

Batch

M101331

24/8/3(5)

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.13

M.F.

06/08/08

(5)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

0608-09

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0

D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty	Part Number	Description
2	D2806-1	Bushing

Batch

B26565 ✓

W/O:		WORK ORDER CHANGES					
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 27269

Part Number: D412630024

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty	Part Number	Description
2	D2806-3	Bushing

Batch

B26160 ✓

23.0

D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Strut

Pick: Packing Kit

Qty	Part Number	Description
1	D2810-5	Strut

Batch

B27103 ✓

24.0

D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Spacer

Pick: Packing Kit

Qty	Part Number	Description
2	D3396-1	Spacer

Batch

B26771 ✓

25.0

AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description
1	AN4C6A	Bolt

Batch

M100651 ✓

26.0

AN4C10A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description
1	AN4C10A	Bolt

Batch

M100273 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Wednesday, 5/31/2006 7:32:46 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 27269

Part Number: D412630024

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

AN4C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN4C15A

Bolt

M100447 ✓

28.0

AN44C7A

Eybolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Eybolt

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN44-C7A

Eybolt

M19620 ✓

29.0

AN5C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN5C15A

Bolt

M100229 ✓

30.0

MS210434

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

Description

Batch

4 MS21043-4

Nut

M101390 ✓

31.0

MS210435

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 15.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

Description

Batch

3 MS21043-5

Nut

M18535 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/08/15

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Wednesday, 5/31/2006 7:32:46 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 27269

Part Number: D412630024

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

NAS1515H4

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 35.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

Description

Batch

7 NAS1515H4

Washer

M101369 -

33.0

NAS1515H5

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 35.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

Description

Batch

7 NAS1515H5

Washer

M100435

06/08/03 (5)

34.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

06/08/04 (5)

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-024

Location:

PPP Rev: A

LB

06/08/10 (5)

36.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/08/15

Job Completion



U 06.08.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

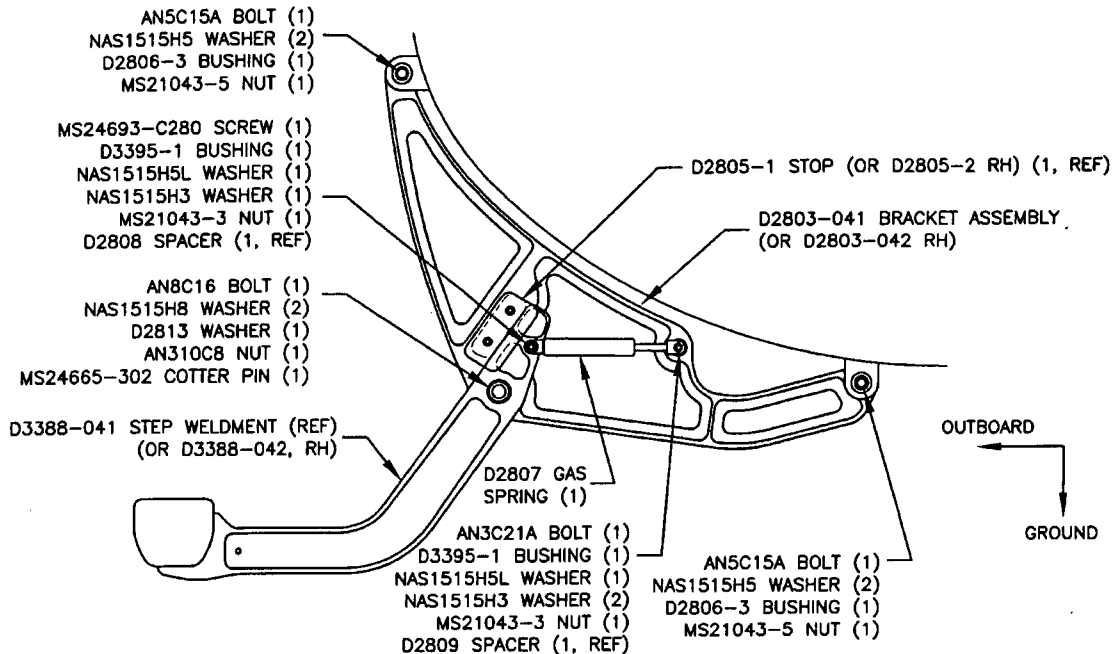
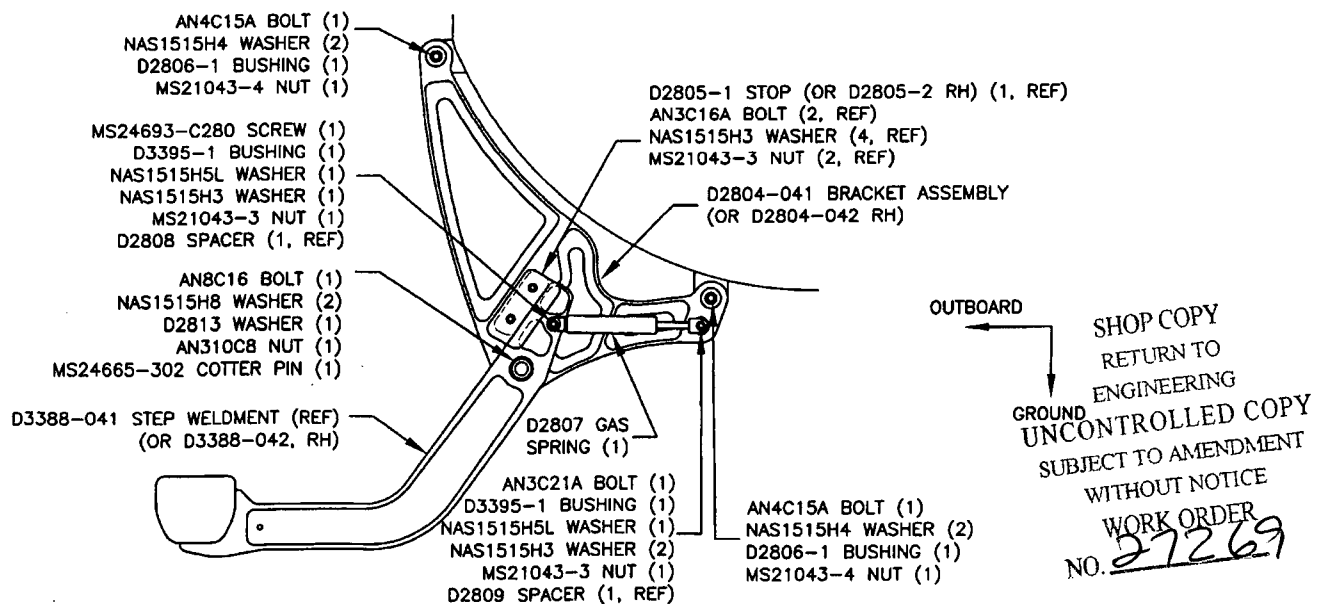
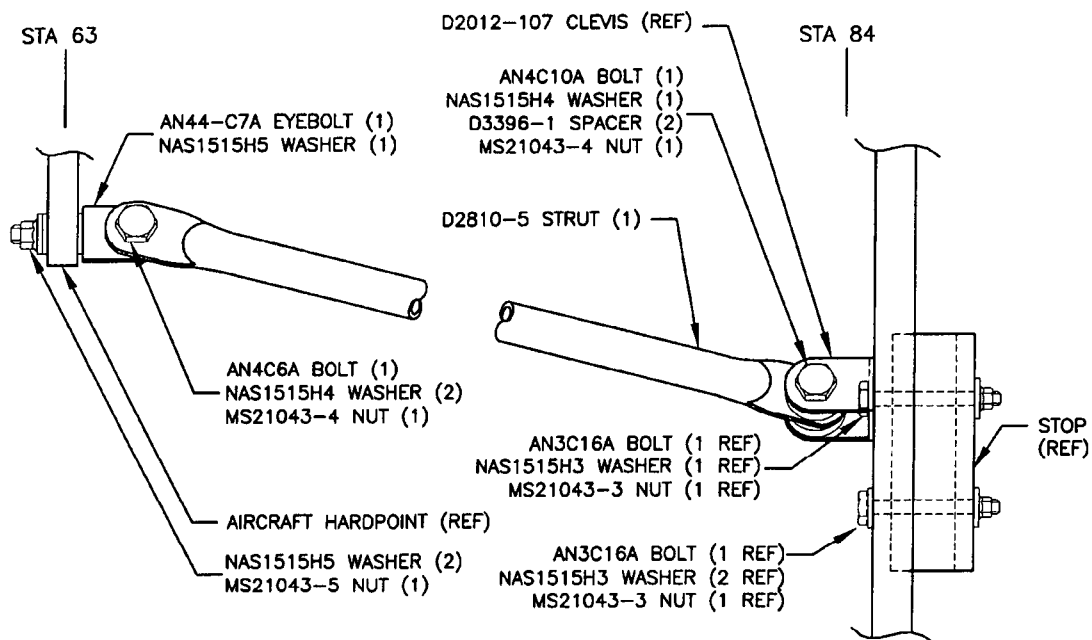
**D412-630-023/-024 Heli-Access-Step™ Installation****FIGURE 11 – STA 84.29 for D412-630-023/-024 Heli-Access-Step™ Installation**  
(View rotated 90° CW)**FIGURE 12 – STA 155.06 for D412-630-023/-024 Heli-Access-Step™ Installation**  
(View rotated 90° CW)

FIGURE 13 – Strut Detail for D412-630-023/-024 *Heli-Access-Step™* Installation  
(NOT TO SCALE)



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27269



Date: Friday, 12/01/2007 3:00:13 PM  
User: Linda Lacelle

# Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.  
Job Number : 30251  
Estimate Number : 10804  
P.O. Number : N/A  
This Issue : 12/01/2007 S.O. No. : N/A  
Prsht Rev. : NC  
First Issue : N/A Type : OVERHEAD  
Previous Run : 30247

Drawing Name : D412-630 - ECN 903

Part Number : Z\_CUSTOM  
Drawing Number : UPDATE PAPERWORK  
Project Number : N/A  
Drawing Revision : N/A  
Material : N/A  
Due Date : 19/01/2007

Qty: 1 Um: Each

Written By :  
Checked & Approved By :  
Comment :

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

ADD NEW PAPERWORK TO KITS IN STOCK  
JCAB STC STC-112-2-TYO

D412-630-011 B 1370 2<sup>ix</sup>, B 20227, 2<sup>x</sup> = 3 stx  
D412-630-012 B 1370 1<sup>ix</sup> B 20228 2<sup>x</sup>  
D412-630-023 B 26501 1<sup>x</sup> B 27271 2<sup>x</sup> B 27267 3 B 27088 1<sup>x</sup> = 6 stx  
D412-630-024 B 28197 2<sup>x</sup> B 27089 1<sup>x</sup> B 27069 1<sup>x</sup> = 4 stx  
D412-630-111 B 15054 2<sup>x</sup>  
D412-630-112 B 15055 2<sup>x</sup>

2.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/01/15

Job Completion



u 07-01.15